



CLAIMS PENDING AFTER THIS AMENDMENT AND THE INVENTOR'S ANSWER TO
THE REQUEST FOR SPECIES SELECTION (TRAVERSED BY THE INVENTORS)

1. A method of manufacturing a carrier rope, comprising the steps of:

imparting a twist to a plurality of multi filament yarns forming a multi filament yarn assembly;

imparting a second twist to mono filament yarn around the multi filament yarn assembly forming a composite yarn assembly, wherein the multi filament yarn assembly is not further twisted;

braiding a plurality of the composite yarn assemblies forming a braided plait assembly;

and

braiding a plurality of the braided plait assemblies forming a carrier rope.
2. The method of manufacture of Claim 1, wherein the multi filament yarn assembly comprises 4 ends of 700 denier multi filament nylon 6.6.
3. The method of manufacture of Claim 1, wherein the multi filament yarn assembly comprises equal Z twist and S twist yarns.
4. The method of manufacture of Claim 1, wherein the multi filament yarn assembly is imparted with an initial twist comprising 22 twists per foot.

5. The method of manufacture of Claim 1, wherein the multi filament yarn assembly is imparted with an initial twist comprising from 20 to 30 twists per foot.
6. The method of manufacture of Claim 1, wherein the multi filament yarns forming the multi filament yarn assembly comprise nylon.
7. The method of manufacture of Claim 1, wherein the multi filament yarns forming the multi filament yarn assembly comprise polyester.
8. The method of manufacture of Claim 1, wherein the multi filament yarn assembly comprises from 2500 to 5400 tex.
9. The method of manufacture of Claim 1, further comprising the step of applying a protective coating to the multi filament yarn assembly.
10. The method of manufacture of Claim 9, further comprising the step of dipping the multi filament yarn assembly in a polyurethane based solution bath.
11. The method of manufacture of Claim 1, wherein the mono filament yarn comprises from 0.20 to 0.32 mm in diameter.
12. The method of manufacture of Claim 1, wherein the monofilament yarn is 0.24 mm in

diameter.

13. The method of manufacture of Claim 1, wherein the composite yarn assembly comprises Z twist monofilament yarns.

14. The method of manufacture of Claim 1, wherein the composite yarn assembly comprises S twist mono filament yarns.

15. The method of manufacture of Claim 1, wherein a single mono filament yarn is twisted around the multi filament yarn assembly, wherein the multi filament yarn assembly is not further twisted.

16. The method of manufacture of Claim 1, wherein the braided plait assembly comprises equal Z twist and S twist ends of the composite yarn assembly.

17. The method of manufacture of Claim 1, further comprising the step of heat setting the individual braided plait assemblies prior to braiding the braided plait assemblies to form the carrier rope.

18. The method of manufacture of Claim 1, further comprising the step of pre-stretching the individual braided plait assemblies prior to braiding the braided plait assemblies to form the carrier rope.

19. The method of manufacture of Claim 1, further comprising the step of braiding the composite yarn assemblies on a 16 carrier braider to form the braided plait assembly.
20. The method of manufacture of Claim 19, wherein the 16 carrier braided plait assembly comprises a pick repeat of 102ppf.
21. The method of manufacture of Claim 1, further comprising the step of braiding the composite yarn assemblies on a 32 carrier braider to form the braided plait assembly.
22. The method of manufacture of Claim 1, further comprising the step of braiding the composite yarn assembly about a core forming a cored braided plait assembly.
23. The method of manufacture of Claim 22, wherein the core comprises three strands of 8400tex nylon.
24. (Cancelled)
25. The method of manufacture of Claim 1, further comprising the step of braiding the braided plait assembly on an 8 carrier braider.
26. The method of manufacture of Claim 25, wherein the 8 carrier rope comprises a pick repeat of 21ppf.

27. The method of manufacture of Claim 1, further comprising the step of braiding the braided plait assembly on a 16 carrier braider.

28. The method of manufacture of Claim 1, further comprising the step of braiding the braided plait assembly about a core forming a cored carrier rope.

29. The method of manufacture of Claim 1, further comprising the step of applying a protective coating to the carrier rope.

30. The method of manufacture of Claim 29, further comprising the step of dipping the carrier rope in a polyurethane based solution bath.

31. A method of manufacturing a carrier rope comprising the steps of:

imparting a twist to four ends of 700 dtex multi filament nylon 6.6 in equal Z and S twist yarns forming a multi filament yarn assembly;

imparting a second twist to a single mono filament nylon 6 yarn around the multi filament yarn assembly forming a composite yarn assembly, wherein the multi filament yarn assembly is not further twisted;

braiding eight Z twist ends and eight S twist ends of the composite yarn assembly forming a braided plait assembly;

braiding eight ends of the braided plait assemblies forming a carrier rope;

applying a protective coating to the carrier rope; and

heat setting the carrier rope

32. A method of manufacturing a carrier rope comprising the steps of:

imparting a twist to a plurality of multi filament nylon yarns in equal Z and S twist yarns
forming a multi filament yarn assembly;

imparting a second twist to mono filament nylon yarn around the multi filament yarn
assembly forming a composite yarn assembly, wherein the multi filament yarn assembly is not
further twisted;

braiding sixteen ends of the composite yarn assembly forming a braided plait assembly;

braiding eight ends of the braided plait assembly forming a carrier rope;

applying a protective coating; and

heat setting the carrier rope.

33-131. (Withdrawn from consideration in response to the Examiner's request for species
selection, traversed by the Inventors.)